

Work Order ID 80206

80206

Page 1

March 27, 2012 10:46:50 AM

Item ID: D2761-108 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Extrusion (HPK)
 Start Date: 2/14/12 Start Qty: 1,170.00 *1170* Cust Item ID:
 Required Date: 3/02/12 Req'd Qty: 1,170.00 *1170* Customer:

Reference:

Approvals: Process Plan: CL Date: 12/02/14 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2761	Rev A1

100 PURCHASING 0.00
 100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 16344 a) Extrude as per Dwg D2761b) Material: CL 12/02/14 1170ft
 6061-T6 (QQ-A-200/8)c) No tooling ID markd) Extrusion is symmetric
 about center linee) Caradon Indalex Die# MS-19021f) Order at 108"
 longg) Material certification required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.00
 Packaging Ensure material certification is attached CL 3/27 1170ft

120 QC6- Inspect dimensions to drawing 0.00
 120
 QC Memo 0.00
 Quality Control Ensure certification comply to Dwg D2761 Check hardness with Webster instrument 8/2/03/28 1170

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>MAT07</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/12

12-04-2

Picklist Print

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Work Order ID: 80206

Parent Item: D2761-108

Parent Item Name: Extrusion (HPK)

Start Date: 2/14/12

Required Date: 3/02/12

Start Qty: 1,170.00

Required Qty: 1,170.00

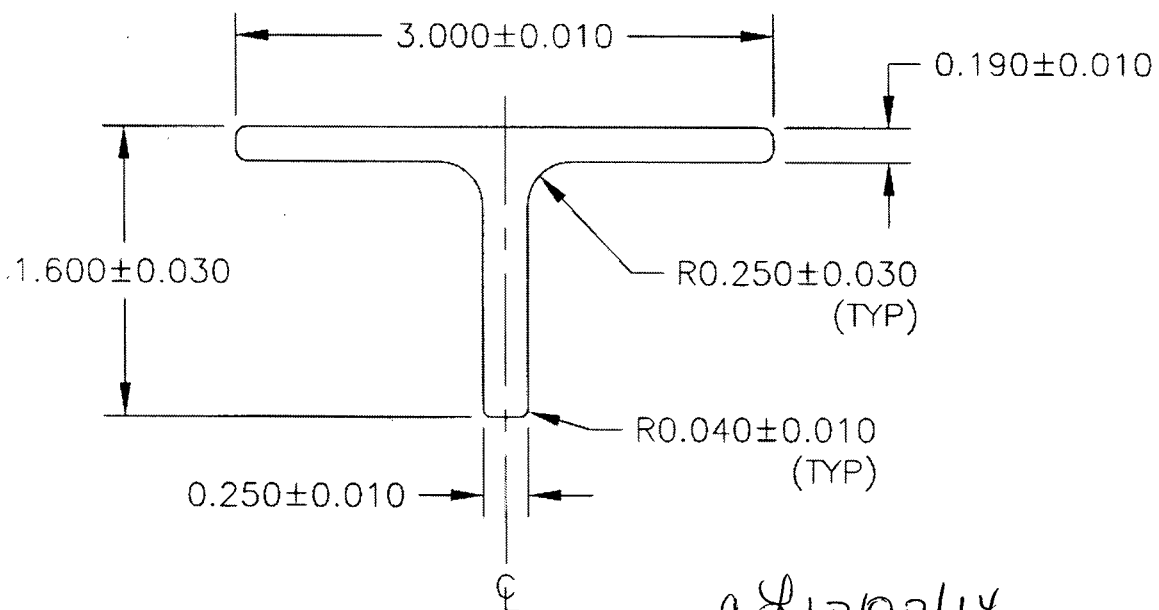
Comments: B01.05.03Re formatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108P Extrusion		Purchased	No			100	f	0.0000	1	1170		6/23/22	1170



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MOY</i>	APPROVED <i>JS</i>	DRAWING NO. D2761	REV. A SHEET 1 OF 1
DATE 98.03.16		TITLE EXTRUSION	SCALE 1:1
A	98.03.16	NEW ISSUE	
AI	01.04.17	ADD NOTES 4 & 5 # CP	

RELEASED
98.04.05 KE



1. MATERIAL: 6061-T6 (QQ-A-200/8).
2. NO TOOLING ID MARK.
3. EXTRUSION IS SYMMETRIC ABOUT CL.
4. MANUFACTURED USING CARADON INDALEX DIE # MS-19021
5. PART NUMBER IS D2761-XXX WHERE XXX IS CUT LENGTH IN INCHES
EG. D2761-108 IS 108" LONG



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16344

Purchase Order Date 3/05/12

PO Print Date 3/06/12

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2761-108P	Extrusion	4/13/12 Yes	1,100.00 f	Yours ppd	\$1.2818	\$1,410.00
1170 P161							
Special Ins:			EXTRUDE AS PER DWG D2761 REV. A B80206 MATERIAL: 6061-T6 AS PER QQ-A-200/8 EXTRUSION IS SYMMETRIC ABOUT CENTER LINEE NO TOOLING ID MARK 1100 FT IS ABOUT 123 PCS				
2		SERVICE TOOLING CHARGE DIE	4/13/12 Yes	1.00 Each	Yours ppd	\$1,410.0000	\$1,410.00

PO Total:

\$2,820.00

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 3/06/12

Date Entered Date d'entrée	03/06/2012	Ref#	10544	Terms Termes	10-1-10 Net 30	Freight Fret		Page #	1
CAR	DLB	Order Type/Type de commande			SO	Date Ordered/Date de commande		03/06/2012	

Acknowledgement/Accusé de réception

SOLD TO/VENDU A:

46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO/EXPÉDIÉ À:

46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

Customer Part Number/ Numéro de pièce du client	Quantity Ordered/ Quantité commandée	Die Number/ Die Nombre	Length/Longueur	Alloy/ Alliage	Signature Aluminum Order Number/ Numéro de commande	Description	Estimated Ship Date/La date d'expédition estimée	Total Price Per Uom/ Prix total par unité de mesure
D2761-108P	123	DAA-7	108.0000 IN	6061 T6	104893-001-001	9FT MILL 6061 T6 Part #: ----- DAA-7-1 PC Ordered: 123	03/26/2012	25.0181

Acknowledgement/Accusé de réception

NO RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION. NO RETURN MATERIALS/Ne sont acceptés pour CREDIT SANS AUTORISATION. Visit us at www.signaturealuminumcanada.com

The above prices are being quoted based on price in effect at the time of shipment. A component of the above quoted price represents the cost of commodity aluminum; the price of which may fluctuate between the time of this quote and the time of shipment. Accordingly, the above quoted price may be revised, upward or downward, based on the commodity price of aluminum in effect at the time of shipment, which shall be determined by utilizing the prior month's average aluminum spot price as reported each month in Metal Week magazine. The above quoted price may also be revised as a result of a subsequently announced industry-wide price increase in effect as of the promised shipment date.

Signature Aluminum ("Seller") acknowledges receipt of Buyer's order as transcribed above. Pursuant to Seller's acknowledgment in the event of any error, if Seller does not receive written notice within the days of the date of this acknowledgment, then this acknowledgment, including the terms and conditions on the reverse side hereof (collectively, this "Agreement"), shall be deemed correct and complete and accepted by Buyer and shall represent the entire agreement between Buyer and Seller with respect to the subject matter hereof. In reliance hereof, Seller is authorized to commence production and shipment in accordance with the provisions of this Agreement, and Buyer agrees to accept such shipment.

End

GST/TPS 872527965
QST/TVO 1020914242

FORM NO. 373

PRELIMINARY

FOR APPROVAL ONLY
MUST BE SIGNED BEFORE RELEASE

AUTHORIZATION TO BEGIN DIE CONSTRUCTION
This drawing is not necessarily an exact copy of the customer's original. By your signature on this print you agree to accept the design, dimensions, and ID mark location as shown and to accept all legal responsibility for infringement of patents, copyright or industrial design relating to this drawing and to hold the SIGNATURE ALUMINUM and its affiliates harmless from any claims, suits, actions, or demands arising therefrom. Please sign and return as soon as possible. Die construction cannot proceed until signed approval is received. If not shown, please indicate exposed surfaces.

APPROVED BY: *[Signature]*

APPROVAL DATE: *10/27/80*

NOTE:
CUSTOMER ASSUMES
BURDEN OF PROOF OF SIGNATURE ALUMINUM
METAL IDENTIFICATION WITH NO I.D. MARK.

© Critical Characteristic

WARRANTY

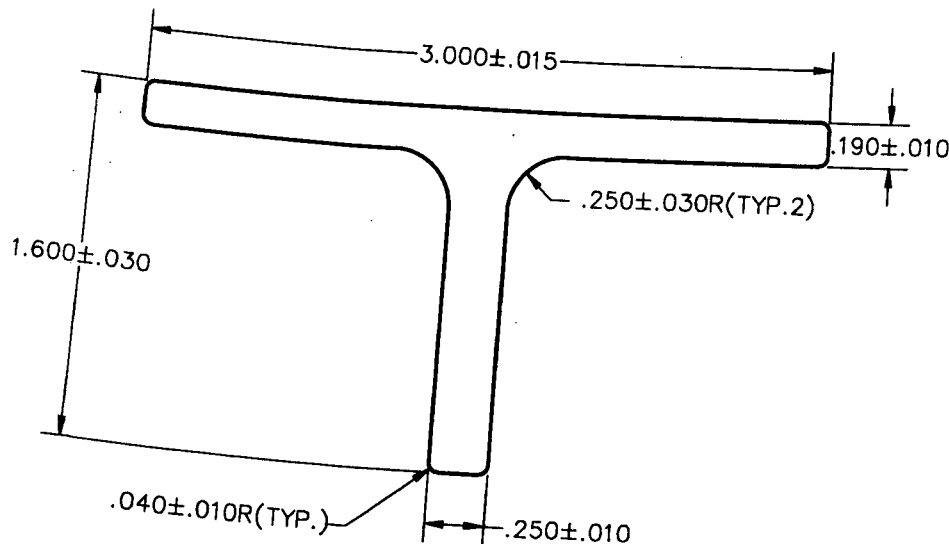
Signature warrants that the product(s) supplied by Signature shall be free from defects in workmanship and material and shall conform to all descriptions and specifications, as agreed between Signature and Purchaser. SIGNATURE DISCLAIMS ANY OTHER WARRANTY, EXPRESS OR IMPLIED, WHETHER CREATED BY CONTRACT, BY STATUTE OR OTHERWISE BY OPERATION OF LAW, INCLUDING ALL WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

For any product that is not included in Signature's standard product line offered for sale generally in the usual course of Signature's business, it is agreed that Purchaser has engaged Signature to manufacture such product to Purchaser's specifications and requirements. Signature shall not be responsible for the adequacy of the materials incorporated in such product or for testing or otherwise determining the sufficiency and applicability of the design. Signature shall not be responsible for determining or assuring that such product or the use or application of such product conforms with applicable federal, state or local laws, rules or regulations. Signature's only warranty with respect to such products shall be as set forth above. All designs, plans, prints, or drawings of whatever kind prepared by Signature with respect to such products are and shall remain the sole property of Signature.

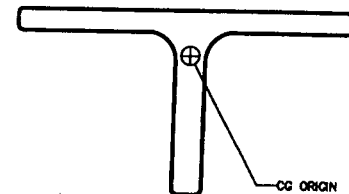
Standard Aluminum Association tolerances apply unless otherwise noted.

CUST PART #	DIE NUMBER	REV
D2761 (REV A1)	DAA-7	
CUST PART NAME	REL. DATE	FINISH MILL
CUSTOM T SHAPE		
PROPOSAL	REL. DATE	FINISH MILL

STRUCTURAL STREAKS EXPECTED,
NOT A CAUSE FOR REJECTION.



NO EXPOSED SURFACES



SCALE 1:1

LOCATION	---
COPY NO.	---
PRIMARY PRESS	---
ALT. PRESS	---
CAVITIES	---
STACK SIZE	---
DIE TYPE	---
HOLDER	---
BOLSTER NO.	---
BO. LOC.	---
SUB BO. NO.	---
SUM	---
DIE	---
FEEDER	---
BACKER	---
BA. LOC.	---
ROMI-SHAPE	---
CAV. DEPTH	---
CAV. C/D	---
DIE MAKER	---
ORDER NUMBER	---
DATE ORDERED	---
DATE REQUESTED	---
PRICE \$	---
ORDER CODE	---
<input type="checkbox"/> NEW <input type="checkbox"/> REPLACE <input type="checkbox"/> INTERDIE <input type="checkbox"/> BACKUP <input type="checkbox"/> REINSTATE <input type="checkbox"/> REPAIR <input type="checkbox"/> REVISE <input type="checkbox"/> UNIT <input type="checkbox"/> DIE AND FEEDER <input type="checkbox"/> DIE ONLY <input type="checkbox"/> BACKER ONLY <input type="checkbox"/> FEEDER ONLY <input type="checkbox"/> MANDREL ONLY <input type="checkbox"/> BOLSTER SUIT	

DART AEROSPACE LTD.



UNSPECIFIED WALLS:		<input type="checkbox"/> BOILER TO SUIT			
mm		MASS:	1.691	kg	1.136
in		EST PER:	225.60	mm	8.882
UNSPECIFIED RADII:					
mm		OUT PER:		mm	in
in		EXP PER:		mm	in
DATE:		02/28/12			
JAG		BUFF PER:			
DRAWN:		BUFF TURNS:			
SCALE:		CLASS:			
2:1		Solid			
FACTOR:		133			
metric		8			
imperial					
THM BAR:		NO			
C.C.D.:		76.28			
mm		3.003			
in					
P&D CODE:		NO			
P&D AREA:					
mm ²		in ²			

DESCRIPTION OF REVISION

Standard Nominal Wall Thickness Tolerance Chart (±)

for Circumscribing Circle Sizes Less than 10 inches

0.125 - 0.250 0.006 0.250 - 0.499 0.008 0.500 - 0.999 0.010

0.249 - 0.499 0.007 0.500 - 0.749 0.009 0.750 - 0.999 0.010

Structural values estimated for reference only:

Ix	.0828 × 10 ⁶ mm ⁴	Iy	.1777 × 10 ⁶ mm ⁴	.427	in ⁴
Sx	2.708 × 10 ³ mm ³	Sy	4.665 × 10 ³ mm ³	.285	in ³
CGx	30.58 mm	CGy	38.10 mm	1.500	in

ACCT# 46024

INVOICING AND COMPANY LOCATION

SHIPPING MANIFEST

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

MANIFEST DATE / DATE DU BODEREAU
03-25-12

MANIFEST NUMBER / N° DE BODEREAU
005072

SALES ORDER NUMBER / N° DE COM
104893

SHIP TO / EXPÉDIÉ À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200	SOLD TO / VENDUE À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200
--	---

TERMS / FREIGHT PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT 46024	ORDER DATE / DE LA COM 03/06/12	CUSTOMER PO NUMBER / CLIENT PO Nombre 16344	JOB / FICHIER	FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU	CUST SERVICE REP / REP. SERVICE CLIENTELE DLB
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 005072			CARRIER / TRANSPORTEUR JODEE		

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,258	LB		DAA-7-1	6061 T6		1	1,292	1,283	LB	
	570	KG			108.0000 IN			586	582	KG	
	123	PC			Cut(+): 0.1180 Cut(-): 0.0000 Min: 0 % Max: 0 %				130	PC	
						810981 / 135320	1	1,292	1,283		130 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

Page 1

1	1,292	1,283	LB
	586	582	KG
		130	PC
TOTALS			

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
03/21/2012	5280579	104893	1
Cust PO	B/L No	Lot	Date
16344	005072	810981	03/25/12

Sold To		Ship To	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	
Item No	Part No	Item Description	Cust Part
001	DAA-7-1	9FT MILL 6061 T6	
Gross Weight	1,292 LBS		
Net Qty	1,283 LBS 130 PCS 1 PKG		
Specification		Die Desc	
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HREW
MPA / KSI	MPA / KSI			
328.3 / 47.6	303.5 / 44.0	11.0	0.0	95

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.66	0.28	0.28	0.07	0.91	0.06	0.20	0.02	0.00

S. Mazzotta

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc